\*110\*

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

MACHINE AS PER FOLIO FA869 AND DWG

FOLIO REV: AA DWG REV: 🗛

**DEBURR** 

0.00

	1							DQA:	Date:	
NCR: Yes	/ No			WORK ORDER NON-	CONFOR	MANCE / UP	PDATE	QA Closed:	Date:	
Work Order:			_	DISPOSITION		·	AGAINST DE	PARTMENT	/PROCESS	
Part No.	1		<b>.</b>	Rework Scrap Use-as-is Work Order Update	<b>⊣</b> :	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Occ/Data Equip/Tooling Operator Material Setup Other Process Supplier									,	

**Landing Gear** General Pressure/Forced Bending Bend Grain Ovalized Temperature/Cure Over/Under tolerance Centre Not Concentric to O/S BOM/Route Hardware Part Incorrect Weld Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Instructions Incomplete/Unclear Burrs Part Moved Cuffs Contamination Maintenance Positioned Wrong Countersink Mislabeled Heat Treat Other Power Loss/Surge Inspection Strip in Tube Cut Too Short Misread Offset Ripples in Bend Drill Holes Out of Calibration Torque Waves in Extrusion Drawing Out of Sequence Turning Sequence Finish

Outside Dimensions

**FAULT CATEGORY** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Unapproved

Work Order ID 100265 \*100265\* Page 2 April-22-13 12:52:16 PM \*N900040100\* Item ID: D4016-1 Accept Setup Start **Revision ID:** Stop Hinge Half, Base Item Name: \*30\* **Start Qty: 30.00 Start Date:** 4/22/13 Cust Item ID: **Req'd Qty: 30.00** Required Date: 5/03/13 **Customer:** Reference: Run Process Plan: Date: Tooling: Date: **Approvals:** Stop SPC (Y/N): Date: Date: QC: Reject Tool # Plan Sequence ID/ Operation Set Up/ Tool ID Accept Reject Insp. Qty Number **Work Center ID** Description Code Qty Stamp! **Run Hours** OAS QC2- Inspect parts off machine FAI/FAIB 0.00 120 13/04/26 \*120\* 0.00 Memo Quality Control QC8- Inspect parts - second check 0.00 130 F.L 13/04/28 \*120\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location: 160 \*160\*

0.00

Memo

Packaging

Packaging

											DQA:	Da	te: _	
NCR: Y	es / No				<b>WORK ORDER NON-C</b>		NFOR	MANCE / UP	DATE					
											QA Closed:	Da	te:	
Work Orde	ŗ.				DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	ı	nitial	Act	tion		Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	┙	Date	Verification	n ·	QC Inspector
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					F	AUL	T CATE	GORY						
Landir	ng Gear				General	_	7		_	_		1		
	Bending	3			Bend		Grain		<u> </u>	-	Ovalized		-	Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route		Hardwa	are		_	Over/Under		-	Temperature/Cure
	Cracks				Broken/Damaged	L	4 '	ion Incomplete		_	Part Incorred		$\vdash$	Weld
	Crushed	d/Crimped	ł		Burrs		Instruct	tions Incomplete/	Unclear	_	Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance	L	山	Part Moved			
	Heat Tr	eat			Countersink		Mislabe	eled			Positioned W	/rong		

Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Work Ord April-22-13 12		00265		*100	)265*							Page 3
Item ID: Revision ID: Item Name:	D4016-1 Hinge Half,	Base		Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop	*N:	S1*
Start Date: Required Date Reference:	4/22/13	Start Qty: 30.00 Req'd Qty: 30.00	*30* *30*		Cust Item I Customer:	D:			_	6		.,
Approvals:	Process P QC:		Date:	Tooling: SPC (Y/N):		ate: ate:		J	Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center	ID	Operation Description  QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Re Qty	•	Reject Number	Insp. Stamp
*170*		Memo		0.00						13/	5/6	

Quality Control

MF 13-4-29

NCR: Yes / No				WORK ORDER NON-CONFORMANCE / UPDATE									
		1									QA Closed:	Date	•
Work Ord	er:					DISPOSITION	•			AGAINST DE	PARTMENT	/PROCESS	
Part	No.					Rework Scrap	-	ļ	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR	•	1				Use-as-is Work Order Update		1	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descr	iption of work order update	1	Initial	Act	tion	Sign &		
Cause		Date	Step	Qty	!	or Non-conformance	Cł	nief Eng	Desc	ription	Date	Verification	QC Inspector
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Land	ing (	Gear			_	General	_	_	•	<b></b>	7	_	¬
		Bending	1		<u> </u>	Bend	L	Grain			Ovalized		Pressure/Forced
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	L	Cracks	1		<u> </u>	Broken/Damaged	L	Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimpec	l	L	Burrs	L	Instruct	tions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination	L	_Mainte	enance		Part Moved		
ļ		Heat Trea	at			Countersink	L	Mislabe	eled		Positioned V	Vrong	<del>-</del> -
		Inspection	n Strip ir	n Tube		Cut Too Short		Misread	d		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	/aves in	Extrusio	n $\lceil$	Drawing		Out of 0	Calibration				
·		Turning S	equence	9	Γ	Finish	Г	Out of	Sequence				
Wave/Twist in Tube		Folio		Outside	Dimensions								

DQA:

Date:

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

**Picklist Print** 

April-22-13 12:52:15 PM

Work Order ID:

100265

Parent Item:

D4016-1

Parent Item Name:

Hinge Half, Base

**Start Date:** 4/22/13

Required Date: 5/03/13

Page 1

**Start Qty: 30.00** 

Required Qty: 30.00

Comments:

IPP REV:A NEW ISSUE 09-11-27 JLM VERIFIED BY :DD

IPP Rev:B as per dwg REV.A DD

10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>M304B1.000X1.000</b> 304 bar 1.00 x 1.00	<del></del>	Purchased	No		ta un - e	100	f	10.3200	0.08	2.4	<u>b.a</u>	13/	34 25
				<b>Location</b>		Loc Qty	Lo	c Code					•
				MAT050		10.32							
				→ 1253	40	10.32			2 1	ムベクチャ			

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		i	1								DQA:	Date:	
NCR: Y	es / N	0				WORK ORDER NON-C	ON	NFORM	MANCE / UPDAT		QA Closed:	Date:	
W- 1 0 1	÷					DISPOSITION			A	AGAINST DEF	-	PROCESS	
Work Orde  Part N  NCR N	lo					Rework Scrap Use-as-is Work Order Update		Thern	Machining Si noforming F	rosstube mall Fab Finishing mposite		Water Jet d. Eng. Coor. e/Packaging Supplier	Engineering Quality Other
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Cause	Dat	e	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descriptio	n	Date	Verification	QC Inspector
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	Bend	ng				Bend		Grain		<b>  </b>	Ovalized		Pressure/Forced
	Centr	e Not	Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Crack	s				Broken/Damaged		Inspect	ion Incomplete		Part Incorred	:t	Weld
	Crush	ed/Cri	imped			Burrs		Instruct	ions Incomplete/Unclea	ar 📗	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance		Part Moved		
	Heat	Treat				Countersink		Mislabe	eled		Positioned V	/rong	_

Misread Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Other

Power Loss/Surge

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes Drawing

Finish

Folio

DART AEROSPACE LTD	Work Order:	100265
Description: Hinge Half, Base	Part Number:	D4016-1
Inspection Dwg: D4016 Rev: A	. ,	Page 1 of 1

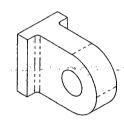
## FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.875	+/-0.010	0.875	~		Vern	69-01
0.25	+/-0.030	0.241	~		3)	11
0.38	+0.030/-0.000	0.392	~		71)	11
R0.03	+/-0.030	RO.030	~		R+6	ref.
0.13	+/-0.030	0.125	7		Vern	6A-01
0.88	+/-0.030	0.875	>		-11	1)
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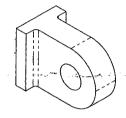
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Measured by:	D.S DAS	Audited by:	FK.	Preliminary	Approval:	
Date:	13/04/26 3-5	Date:	13/04/28		Date:	ř.
	,			2.41		1.2

Rev	Date	Change		Revised	by	<del></del>	Approved
Α :	10.06.07	New Issue		141	又		M
			· · · · · · · · · · · · · · · · · · ·	·	*/	<del>                                     </del>	

D4016-1 HINGE HALF, BASE



D4016-3 HINGE HALF, LID



100265 MC5 1304-24°

**D4016-5 HINGE HALF, LIGHT LID** 

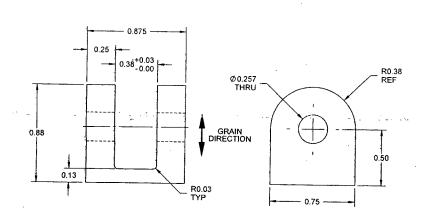
RELEASED 2010 -02- 1 6

А	NEW IS	SUE		JPH	10.01.29	
REV.			DESCRIPTION	BY"	DATE	
DESIGN		AJS	DART AEROSPA	CFI	TD	
DRAWN		AJS	HAWKESBURY, ONTARK			
CHECK	ΞD	9	DRAWING NO.		REV. A	
MFG. AF	PR.	77	D4016	SHEET 1 OF		
APPRO\	/ED	10	TITLE		SCALE	
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DATE	10.0	1.29	COPYRIGHT © 2010 BY DART ALTHIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED NOT TO BE USED YOU AND ANY PARTICLE OF COMMUNICATION OF THE PRIVATE OF	ON THE EXPRE	S CONDITION THAT IT IS	

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0.13 0.250 0.50 R0.03 - 0.13 R0.31 -- 0.563 <del>---</del> REF 0.63 Ø0.257 THRU

GRAIN DIRECTION - 0.88

**D4016-1 HINGE HALF, BASE** 

**D4016-3 HINGE HALF, LID D4016-5 HINGE HALF, LIGHT LID** 

NOTES: 1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276 REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR. PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116) OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160) OR ASTM B211 OR ASTM B212 REF DART SPEC M6061T6B

D

REF DART SPEC M6061T6B

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.09 lbs
-5: 0.01 lbs

DESIGN AJS DART AEROSPACE LTD DRAWN AJS HAWKESBURY, ONTARIO, CANADA CHECKED REV. A D4016 MFG. APPR. SHEET 2 OF 2 APPROVED TITLE SCALE BASKET HINGE DE APPR. DATE COPYRIGHT © 2010 BY DART AEROSPACE LTD
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